

# Work Order ID 48526



Page 1

July 1, 2009 8:57:50 AM

Item ID: D206-547-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Console

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut angle 12.00" long +/- 0.03"

2-Deburr

*Ep 09/07/01* (10)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*- S 02/07/01* (X10)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*umo 09/07/01* (X10)

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July 1, 2009 8:57:50 AM



Page 2

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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00

BR 09-07-01

10



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location 182

0.00



Packaging

Memo

0.00

Packaging

9/7/2 sd 10x

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/08 JF  
MF 09-07-07

# Picklist Print

July 1, 2009 8:57:49 AM

Work Order ID: 48526

Parent Item: D206-547-11

Parent Item Name: Angle, Console

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

✓ M6063T5A0.750W.063

Purchased

No

100

f

57.8439

10.0000



Angle6063T5 .750 X.750 X.063w



112040  
EP08/07/01

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

57.84

111018

21.85

112040

35.99

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

Date: Friday, 12/06/2009 9:53:29 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ANGLE	<i>No Route</i>
<b>Job Number</b> : 48526		
<b>Estimate Number</b> : 12048		
<b>P.O. Number</b> :	<b>Part Number</b> : D20654711	
<b>This Issue</b> : 12/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D206-547 REV F	
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A	
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : F	
<b>Previous Run</b> : 48105	<b>Material</b> :	
<b>Written By</b> :	<b>Due Date</b> : 19/06/2009 <b>Qty:</b> 10 <b>Um:</b> Each	
<b>Checked &amp; Approved By</b> : <u>JUL 09 06 12</u>		
<b>Comment</b> : Est Rev:D    04-11-17    Reformat    JLM		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6063T5A0750W063

Angle6063T5 .750 X.750 X.063w



**Comment:** Qty.: 1.0000 f(s)/Unit    Total : 10.0000 f(s)  
 Material: 6063-T5 (QQ-A-200/9) 0.063" wall  
 M6063T5A750W063)  
 Identify as D206-547-11  
 Batch: \_\_\_\_\_

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut parts to 12.00" length from 0.063" x 0.75" angle

2-Deburr

3.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:53:30 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 48526

Part Number: D20654711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion/



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <b>BW</b>	DRAWN BY <b>RF</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>UP</b>	APPROVED <b>KE</b>	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED  
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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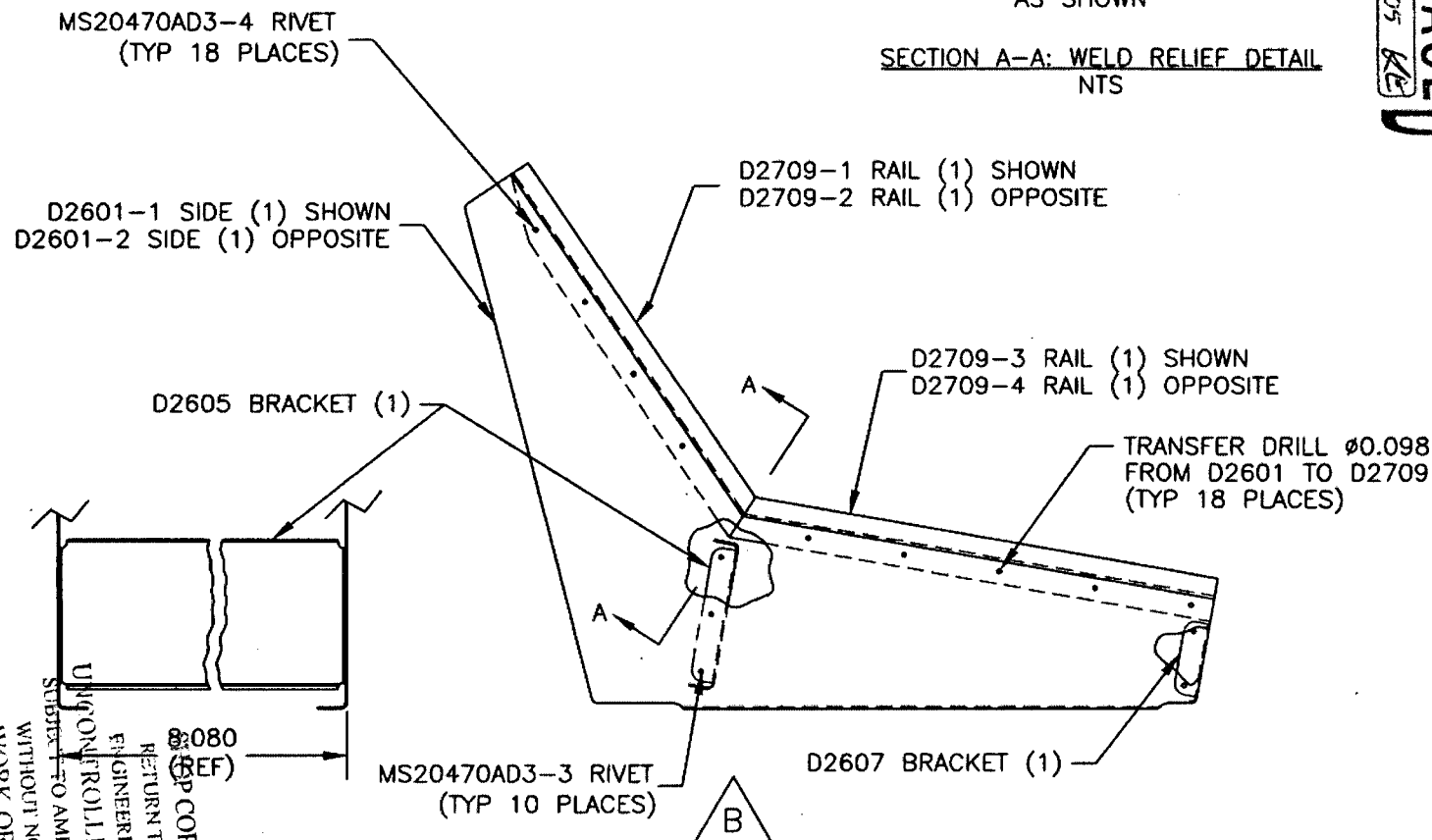
**DART**

RELEASED  
M0705 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	99.02.11	TITLE	D206-547	REV. F SHEET 2 OF 5
		CONSOLE ASSEMBLY		SCALE 1:4

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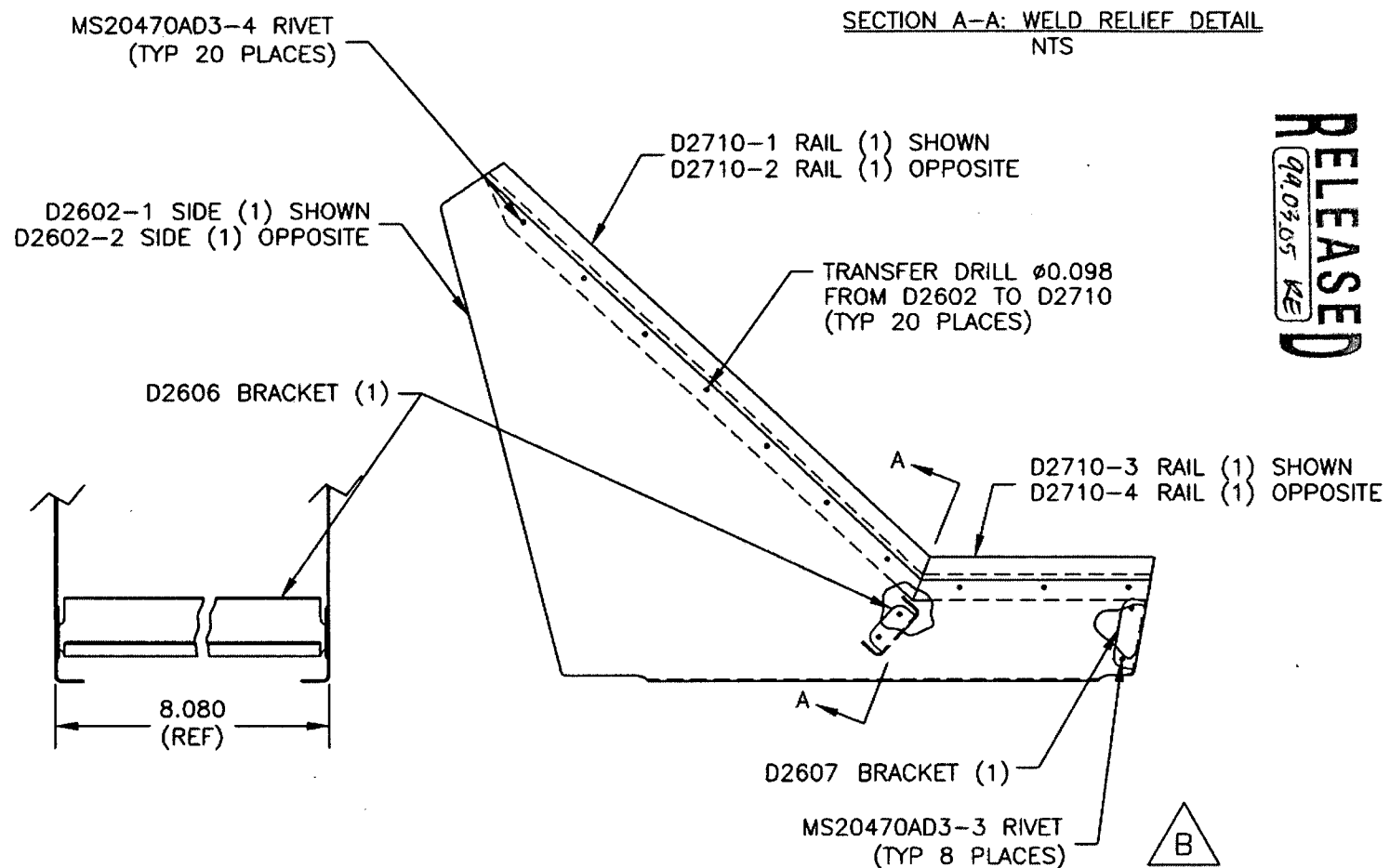
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94.03.05 KE

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CHECKED UP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 3 OF 5
		SCALE 1:4



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

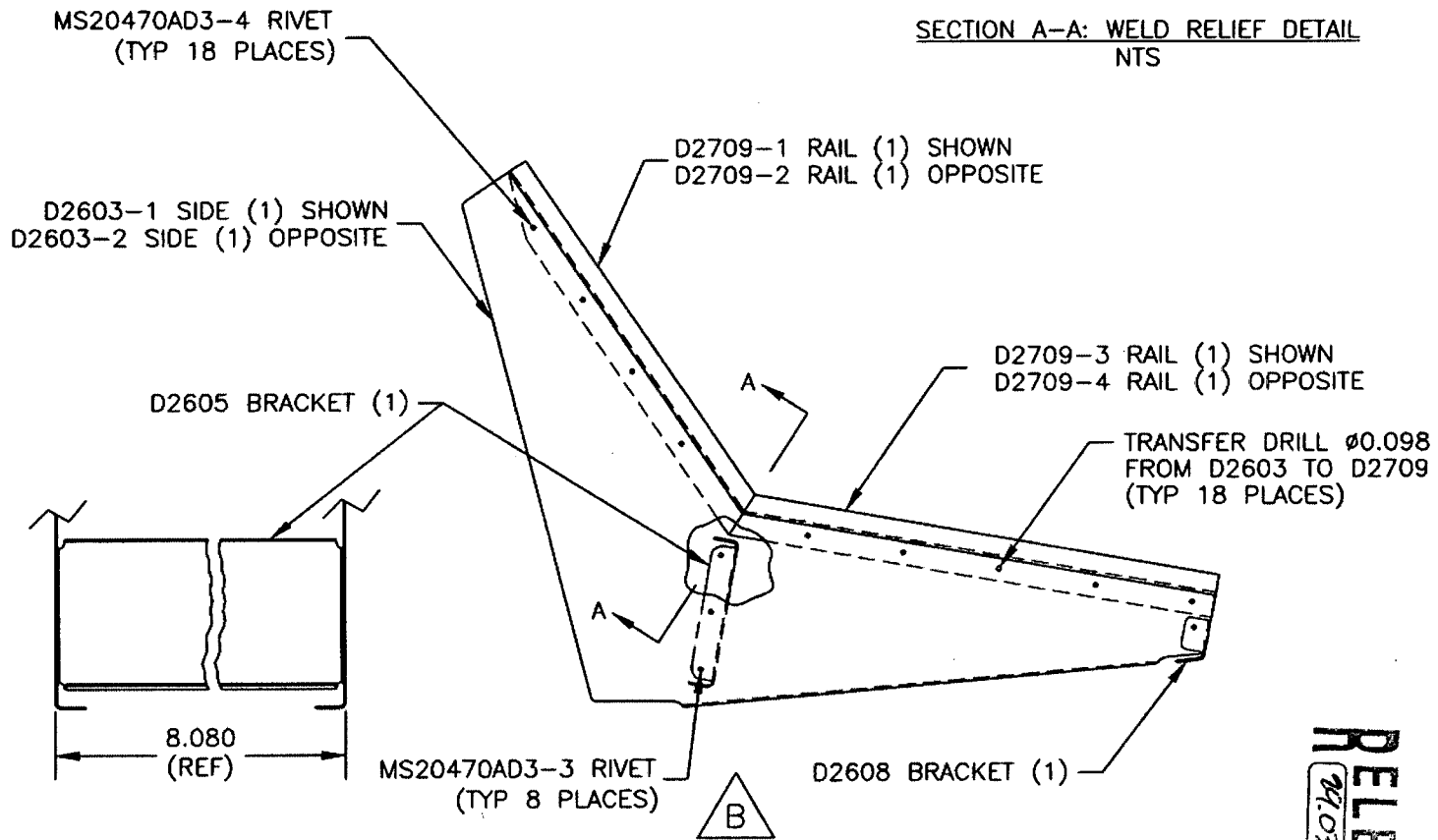
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GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
NOV 03 2005  
RE

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DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

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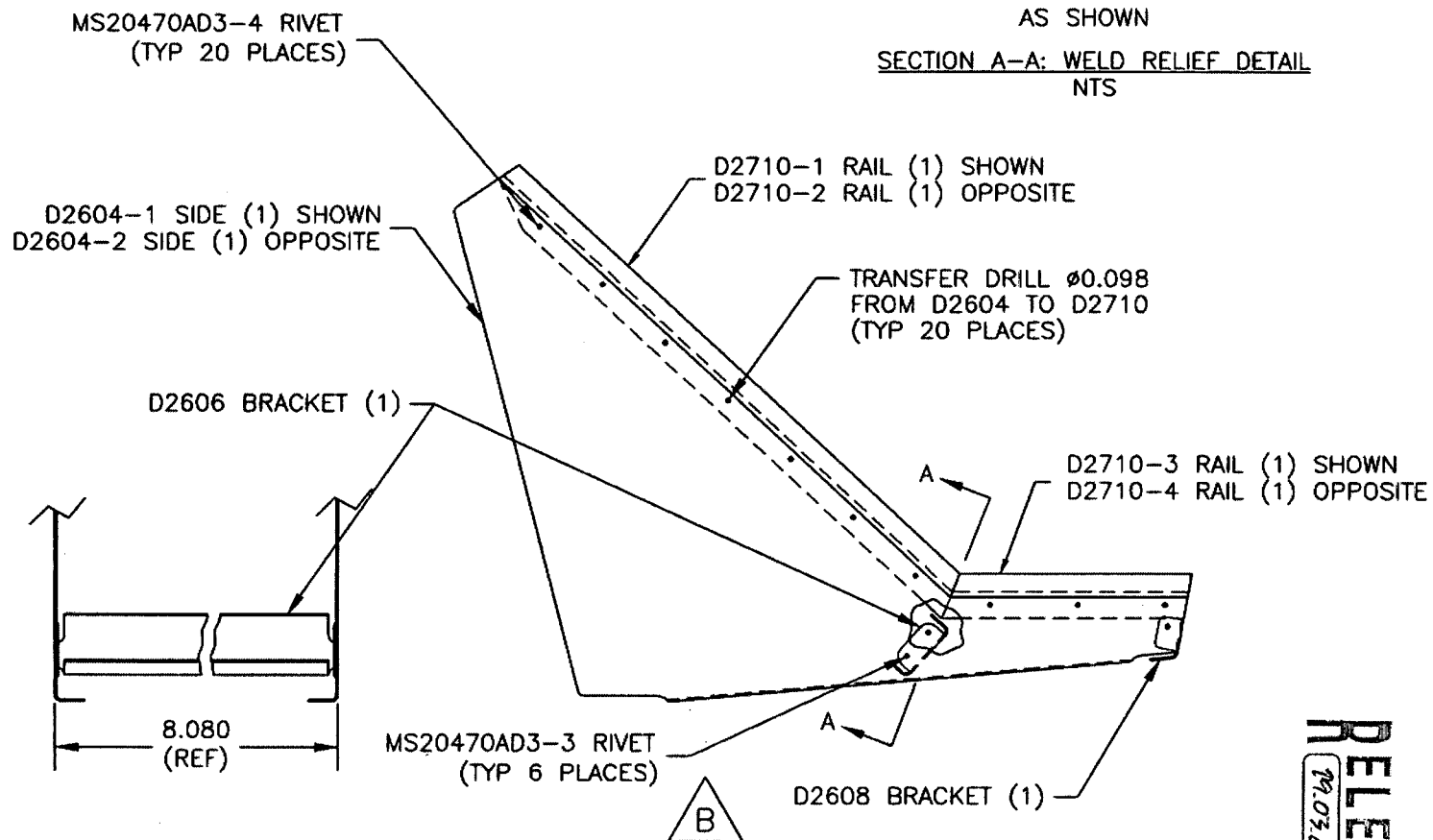
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**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
19.03.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	KE	D206-547
DATE	TITLE	REV. F
99.02.11	CONSOLE ASSEMBLY	SHEET 5 OF 5
		SCALE
		1:4